

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009667**Date Inspected:** 13-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Mr. Qie wen/ Mr. Chen ying xin	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Tower	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

**Trial assembly area**

1.This QA inspector, Baskar Govindarajan, witnessed, ABF personnel's performing Magnetic particle examination in 33 mtr. Elevation of East tower, Lift 1. All indications marked by ABF personnel's have been noted down in respective weld maps for record.

**Machining area**

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 067904 perform SMAW surface repair welding on, Skin C, inside East tower, lift 3. ZPMC CWI Identified as Mr. Liu xiao zhong . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F) - repair.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040723 perform SMAW surface repair welding on, Skin B, inside south tower, lift 3 on 89 mtr. Elevation diaphragm plate. ZPMC CWI Identified as Mr. Liu zhong an . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F) - repair.

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## WELDING INSPECTION REPORT

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052917 perform SAW welding on, Strut flange plate, weld joint no. ND1-STSA3-1-109 mtr.-1-1B. ZPMC CWI Identified as Mr. Chen ying xin . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4221-B-U3C-S-1.

### Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as East tower, Lift 3, D/E corner and AB corner. The weld designations reviewed are as follows:

ESTL 3-4 B/K- Jt. no. 82A–East, Lift 3 – inside D/E corner

ESTL 3-4 B/K- Jt. no. 82B–East, Lift 3 – outside D/E corner ring areas

ESTL3-4 B/K- Jt. no. 85B – East, lift 3 – outside AB corner

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar,Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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